

slg ASAF

Work Order ID 69492

Wednesday, May 11, 2011 12:58:03 PM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11/05/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: M115278 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

11.07.27

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.07.28 1 0 2E 11/07/28

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00				11	01	28	11
130 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo *** mask sides of hinge prior to powdercoat*** Start Time: 9:45 Oven Temperature: 200° Finish Time: 10:15	0.00				1	11-7-29		
140 	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
HandFinish Hand Finishing	Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***	0.00							

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

EBU/08/02 ①

160

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

Packaging

0.00

EBU/08/02 ①

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

*02 11/08/08**11-08-5* ①

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, May 11, 2011 12:58:09 PM

Page 1

Work Order ID: 69492



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	38.0000	2	2		11.07.26	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			38						
					68964		38						
D3914-1 Rib		Manufactured	No			100	Each	2.0000	2	2		11.07.26	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			2						
					69087		2						
D3914-7 Rib		Manufactured	No			100	Each	8.0000	2	2		11.07.26	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			4						
					69277		4						
				WA006			4						
					68175		4						

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Page 2

Work Order ID: 69492

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3

Manufactured No



Hinge Half, Lid

B71941

100 Each

9.0000

3

3

3



11.07.26

Location

Loc Qty

Loc Code

ST109

6

68512

6

WA005

3

67040

3

D4018-5

Manufactured No



Rib

B71939

100 Each

37.0000

9

9

9



11.07.26

Location

Loc Qty

Loc Code

WA005

37

67041

14

69013

23

D4020-5

Manufactured No



Mesh (350 Basket Long, Lid)

71828

100 Each

2.0000

1

1

1



11.07.27

Location

Loc Qty

Loc Code

WA

2

68234

2

D4021-3

Manufactured No



Data Plate

71943

100 Each

3.0000

1

1

1



11.07.27

Location

Loc Qty

Loc Code

WA005

3

66721

3

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Shop Packet Print

Page 2

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Page 3

Work Order ID: 69492

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100

Each

4.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)

B71484

①



5/11/07.20

Location

Loc Qty

Loc Code

WA006

4

67374

4

D4035-043

Manufactured No

100

Each

6.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

B71979

①



5/11/07.20

Location

Loc Qty

Loc Code

WA006

6

67375

6

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

M115050



6/1/08 11/08/01

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

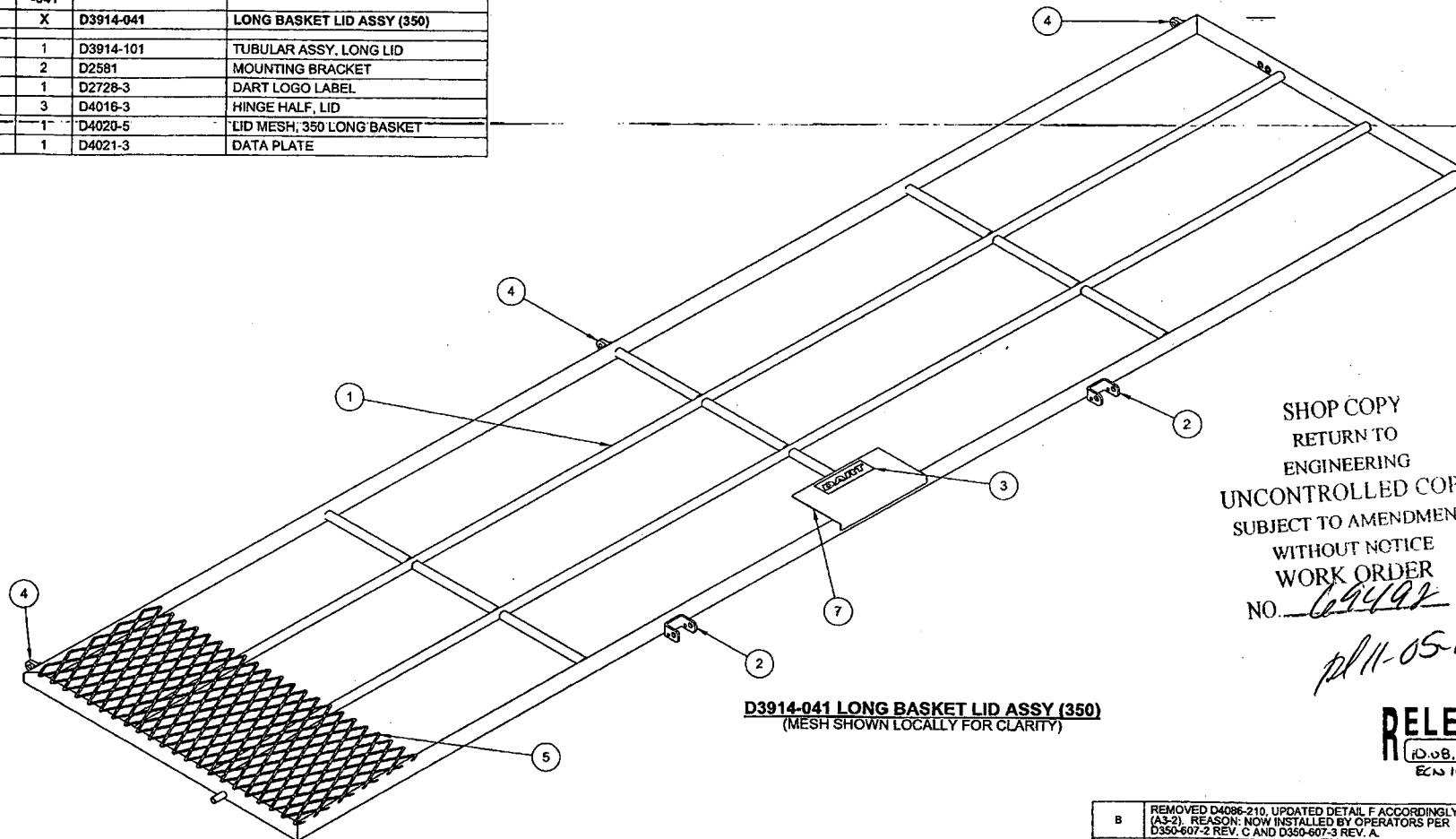
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69492

pl 11-05-11

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	LONG BASKET LID ASSY (350)	NTS
DE APPR.	SC	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

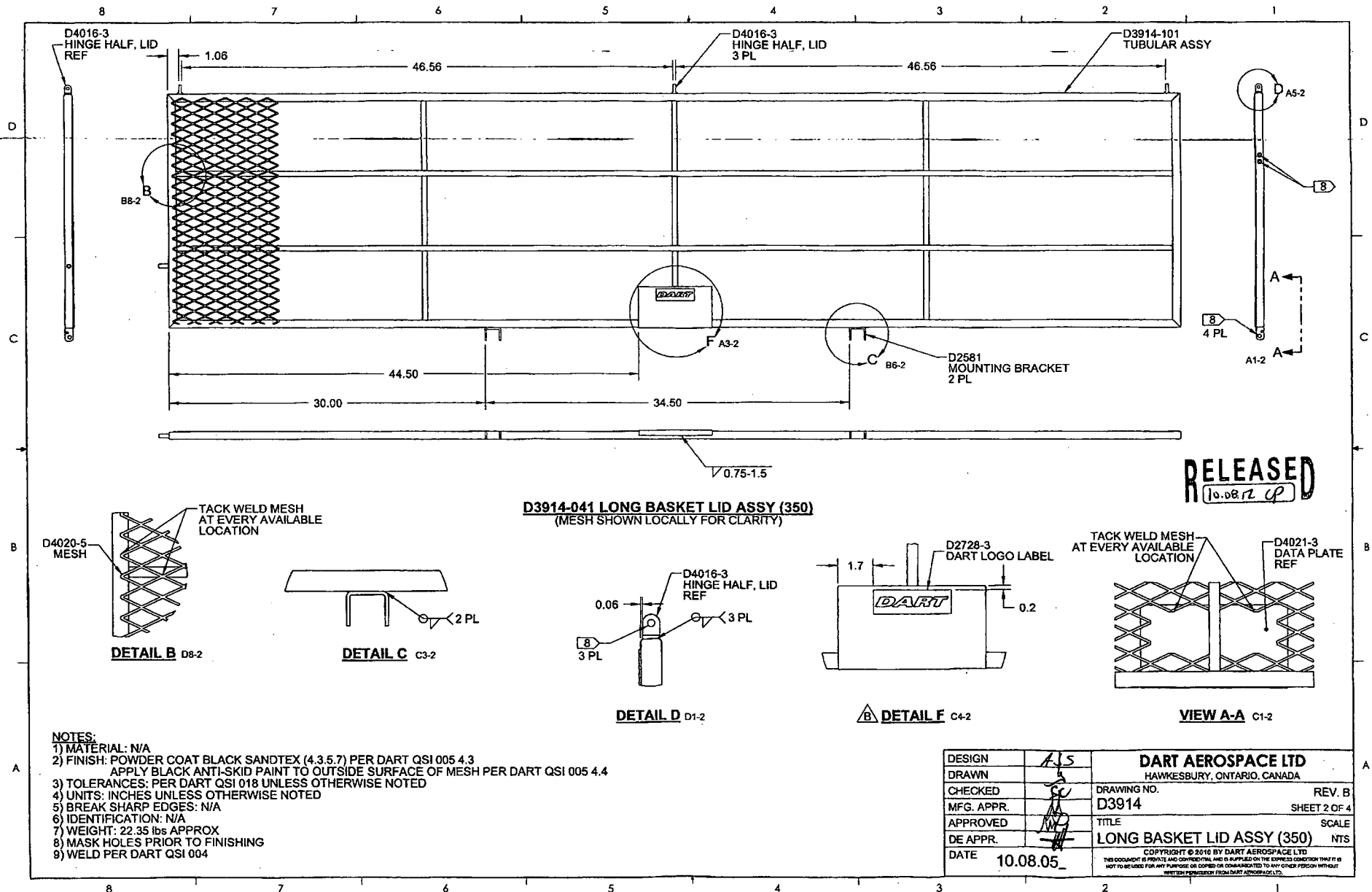
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10069492



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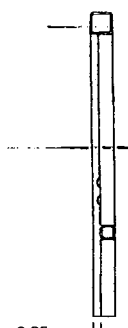
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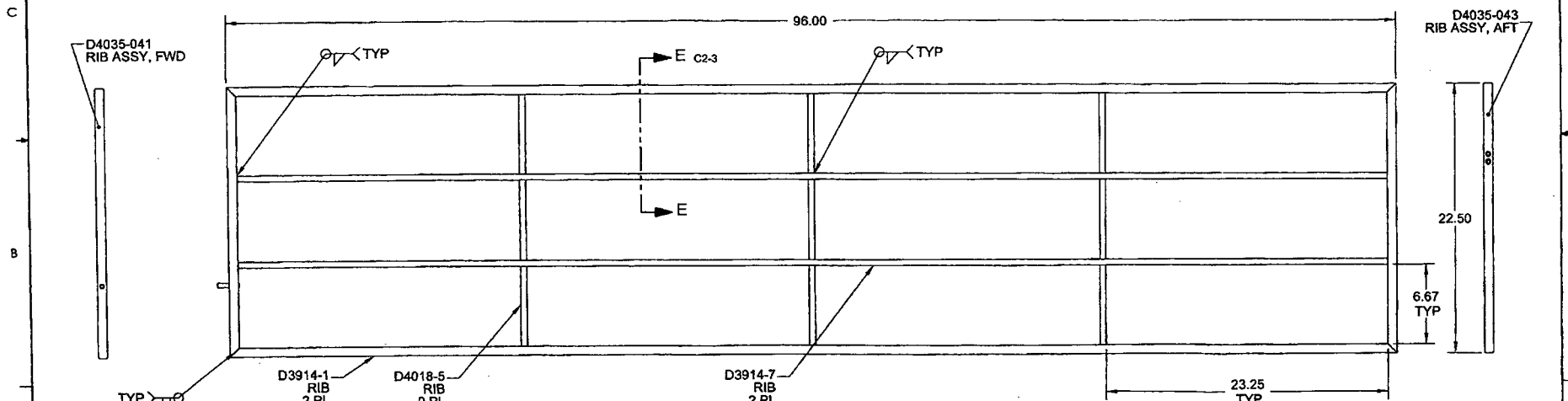
NOTE: Date & initial all entries

who 69492

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RC	DRAWING NO. D3914	REV. B
CHECKED	MP	SHEET 3 OF 4	
MFG. APPR.	MP	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
APPROVED	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS CONTROLLED BY THE EXPIRATION DATE. IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	MP	DATE 10.08.05	

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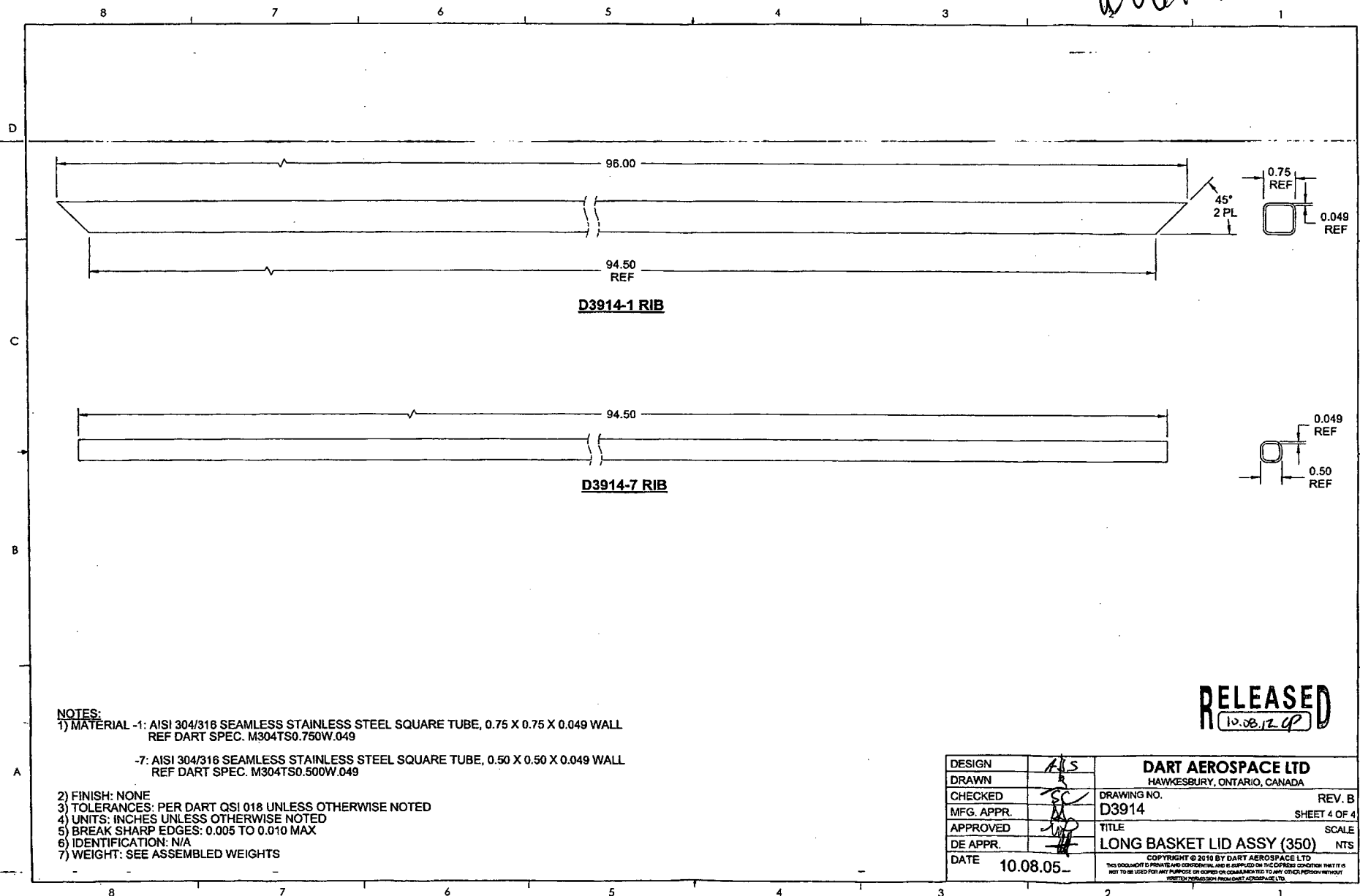
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W069492



NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12.09

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC		SHEET 4 OF 4
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